

Work Order ID 80337

80337

Page 1

February-17-12 8:30:58 AM

Item ID: D3537-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearpad
 Start Date: 17/02/2012 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 02/03/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 12/02/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3537	Rev C

100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3537Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary								
<u>301.063</u>									

W 12 03 02 (4/4)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

W 12 03 02 (4/4)

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

S 12/03/12

(cont)
(4/4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

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Item Name: Wearpad

Start Date: 17/02/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 02/03/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2-
Identify as D3537-1

SB 12/03/05

41

140

0.00

140

Large Fab

Large Fab

Memo

0.00

Large Fab

Qty Description BatchA/R 2059B Hardcoat
M/20392 1-Weld as per Dwg D3537 using Jig DT 82102-Remove any
weld that penetrated through Wearpadif necessary

41

12-03-23/11

150

QC10- Inspect visual per QSI004- ground welds

0.00

150

QC

Memo

0.00

Quality Control

8.7/13/76

cuts
41

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Required Date: 02/03/2012 Req'd Qty: 40.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

8/2/3/26

cuts
(74)

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

170

Powdercoat

Memo

0.00

Powder Coating

START TIME:

2605

OVEN TEMPERATURE:

2635 FINISH TIME:

320°F

m117338

41 2 (OP) 12/03/28

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

41 BRP 3-28

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: FP. 2.

0.00

190

Packaging

Memo

0.00

Packaging

41 BR 12-3-29

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

12/3/29 MF

12-03-29

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Picklist Print

February-17-12 8:31:30 AM

Page 1

Work Order ID: 80337

80337

Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 17/02/2012

Required Date: 02/03/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

58.0000

0.106

4.463158

**

W 12.03.02

M304S16GA

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

58

119653

58

120866

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SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY

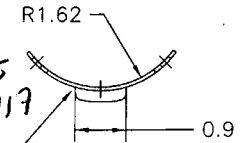
SUBJECT

WITNESS

WORK

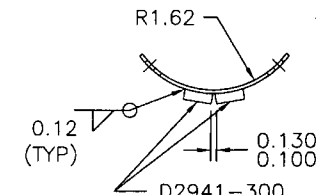
NO. 80337

SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

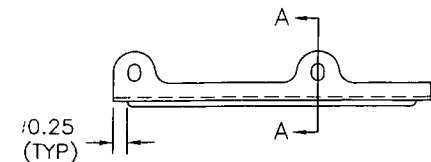
SECTION B-B



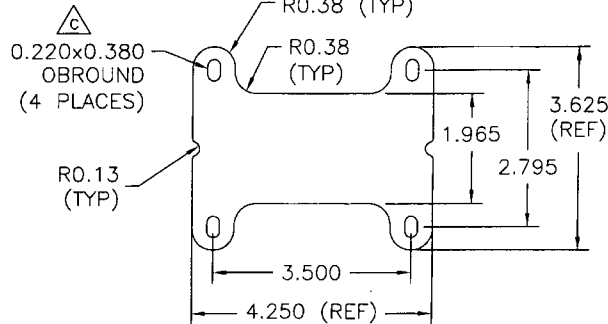
D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07.05.08 PM
PER ECU
962

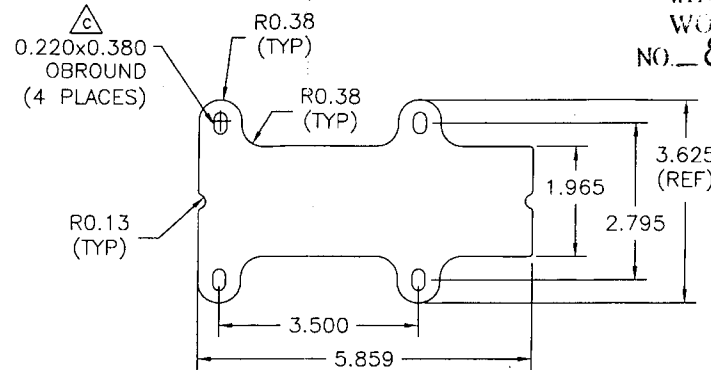
D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)



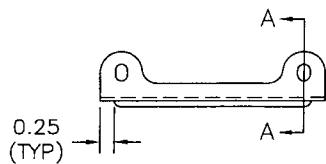
D3537-1F FLAT PATTERN



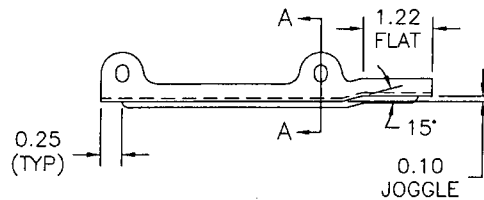
D3537-3F FLAT PATTERN



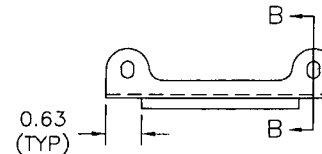
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
SHEET	1 OF 1	SCALE
		1:2

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

UNDER REVIEW
07.05.08 PM
PER ECU
962

5:10

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